

# Work Order ID 77853

December-22-11 8:21:01 AM

\*77853\*

Page 1

Item ID: D4093-1

Revision ID:

Item Name: Bracket

Start Date: 22/12/2011 Start Qty: 12.00

Required Date: 05/01/2012 Req'd Qty: 12.00

Reference:

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.J

QC:

Date: 11/12/22 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4093

C

110

0.00

\*110\*

Waterjet

FLOW CNC Waterjet

Memo

CUT AS DWG

DWG REV:   

PROG REV:   

DEBURR

0.00

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Quality Control

Memo

0.00

101112-09

4 (10)

101112-09

# Work Order ID 77853

**\*77853\***

Page 2

December-22-11 8:21:01 AM

Item ID: D4093-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bracket

Start Date: 22/12/2011 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

132

0.00

**\*132\***

Small Fab

Memo

0.00

Small Fab

DRILL AS PER DWG

135

QC5- Inspect part completeness to step on W/O

0.00

**\*135\***

QC

Memo

0.00

Quality Control

# Work Order ID 77853

December-22-11 8:21:01 AM

**\*77853\***

Page 3

Item ID: D4093-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 22/12/2011 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Chemical Conversion Coat per QSI005.4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

*EF/EL*

*(4)*

*11-12-29*

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

*EF 11/12/29 (4)*

170

Identify as per dwg & Stock Location: *ST 21* 0.00

**\*170\***

Packaging

Memo

0.00

Packaging

*11/12/29 (4) EF*

**Work Order ID 77853**

December-22-11 8:21:01 AM

**\*77853\***

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Item ID: D4093-1

Revision ID:

Item Name: Bracket

Start Date: 22/12/2011 Start Qty: 12.00

Required Date: 05/01/2012 Req'd Qty: 12.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

CK 12/01/02

V11-12-29  
(V1)

# Picklist Print

December-22-11 8:21:05 AM

Page 1

Work Order ID: 77853

\*77853\*

Parent Item: D4093-1

\*D4093-1\*

Parent Item Name: Bracket

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 12.00

Required Qty: 12.00

## Comments:

Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD  
REV:B AS PER REV C 11.09.28 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No				f	42.6600		12			

\*M6061T6B0 750X06 000\*

\*\*

6061T6 BAR .750 X 6.00

BSL-12 28

## Location

## Loc Qty

## Loc Code

MAT003

42.66

112567

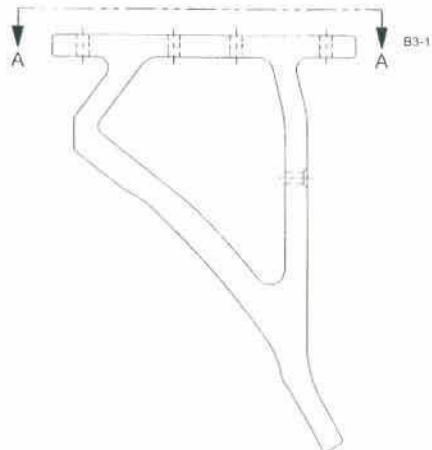
18.66

119231

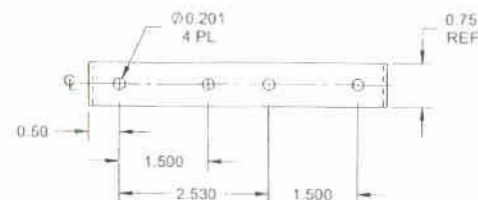
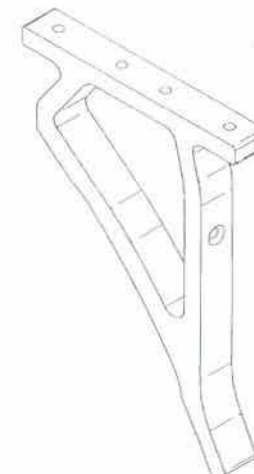
24

119231

10



77853 H.L.J  
11/12/22



SECTION VIEW A-A D6-1

RELEASED  
2011-09-22

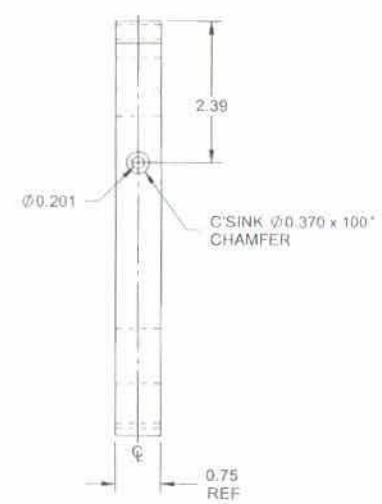
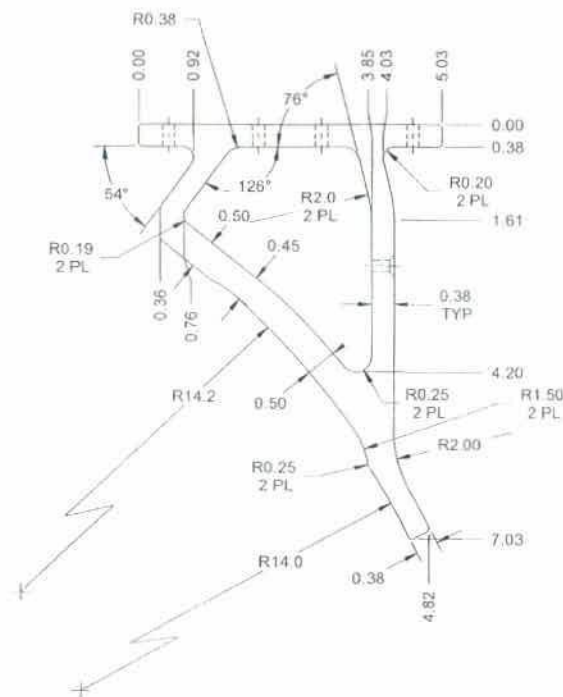
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
OR 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.54 lbs

D4093-1 BRACKET

C	REDRAWN (D4093-1/-3 (ZN B4-1, B4-2), ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5)	RF	11.07.27
B	REDRAWN (D4093-1/-3 (ZN B4-1, B4-2)	RF	11.01.31
A	NEW ISSUE	RF	10.09.16
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4093	SHEET 1 OF 5
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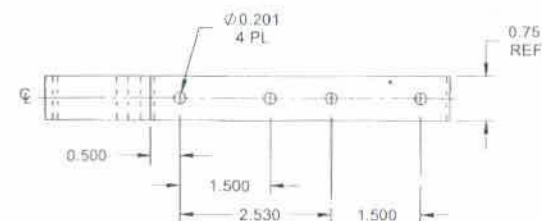
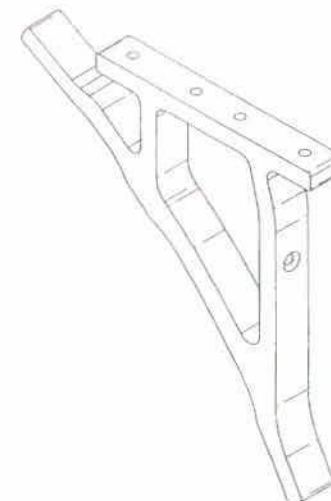
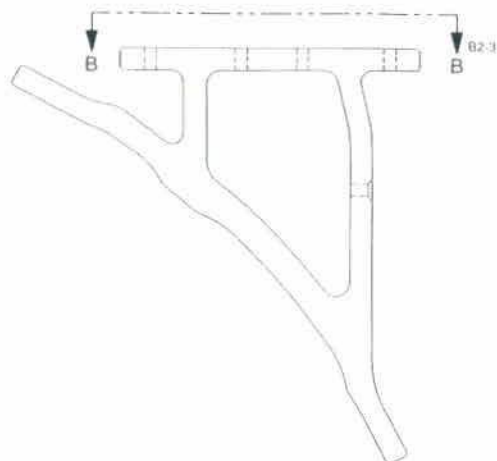
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2011-09-22  
*WMD*

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D4093-3 BRACKET

SECTION VIEW B-B B5-3

## NOTES:

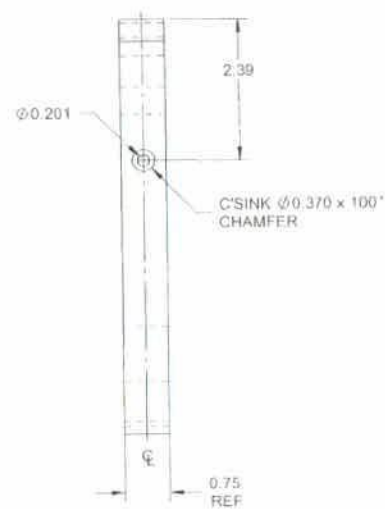
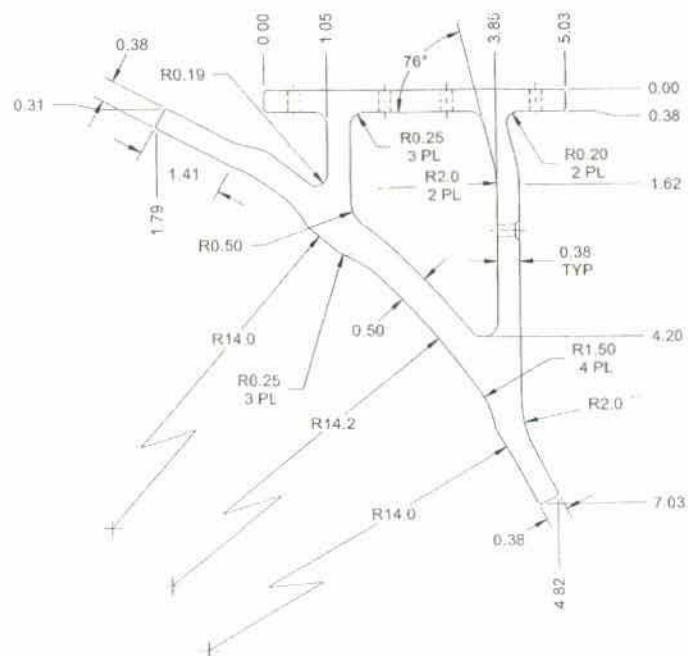
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
OR 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC: M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

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2011-09-22

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D4093-5 BRACKET

**NOTES**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
OR 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

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2011-09-27

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Work Order: 77853

Part Number: 4093-1

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X	First Article	X	Prototype
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Rev	Date	Change	Revised by	Approved
A		New Issue	KJULM	